

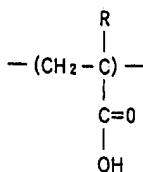
Please enter claims 1-54 shown below and substitute them for corresponding pending Claims 1-54.

**CLEAN VERISON OF CLAIMS**

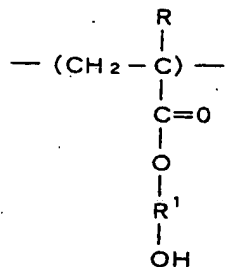
1. (Amended) A highly stable polymer having a principal chain including at least a component unit having an acidic functional group and a component unit having a hydroxyl group wherein an isocyanate compound is amido-bonded with at least a <sup>part</sup> ~~part~~ of the acidic functional group via an isocyanate group of the isocyanate compound <sup>and</sup> ~~anti~~/or urethane with at least a part of the hydroxyl group via an isocyanate group of the isocyanate compound, and an alcohol is ester-bonded with at least a part of the acidic functional group via a hydroxyl group of the alcohol, and wherein the highly stable polymer contains substantially no acid anhydride group.

2. The highly stable resin according to claim 1, wherein the principal chain comprises at least a component unit represented by the below-mentioned formula (1) and a component unit represented by the below-mentioned formula (2):

Formula (1)



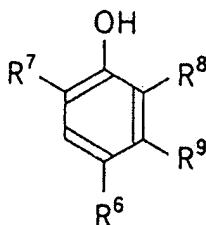
Formula (2)



wherein R is hydrogen or an alkyl group having 1 to 5 carbon atoms, and R<sup>1</sup> is an alkylene group having 2 to 4 carbon atoms.

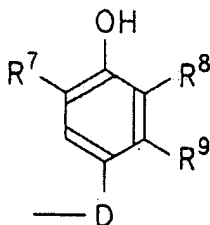
3. The highly stable resin according to claim 1, wherein the isocyanate compound has a reactive group other than the isocyanate group.
  4. The highly stable resin according to claim 3, wherein the isocyanate compound is a radical polymerizable group containing isocyanate compound.
  5. The highly stable resin according to claim 1, wherein the principal chain part of the highly stable resin is formed by polymerization of a compound having a double bond-containing group and an acidic functional group with a compound having a double bond-containing group and a hydroxyl group, using a non-initrile azo-based polymerization initiator or a peroxide-based polymerization initiator.
  6. The highly stable resin according to claim 5, wherein the light transmittance of a 3-methoxy butyl acetate solution of a 20% by weight resin solid component placed in a 1 cm square quartz cell at 400 nm is 60% or more.
  7. The highly stable resin according to claim 5, wherein the light transmittance of a 3-methoxy butyl acetate solution of a 20% by weight resin solid component placed in a 1 cm square quartz cell at 360 nm is 50% or more.
- 
- a<sup>2</sup>
8. (Amended) The highly stable resin according to claim, 1 wherein the isocyanate compound is introduced in the principal chain part of the highly stable resin, using a polymerization inhibitor selected from the group consisting of a phenol-based compound represented by the below-mentioned formula (10) and a phosphite-based compound represented by the below-mentioned formula (6):

Formula (10)



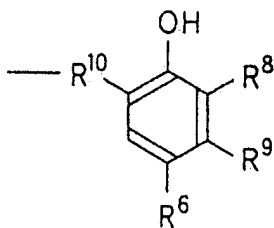
wherein R<sup>6</sup> is hydrogen, an alkyl group having 1 to 5 carbon atoms, or the below-mentioned formula (11):

Formula (11)



wherein D in the formula (11) is -S-, an alkylene group having 1 to 10 carbon atoms or an alkylidene group having 1 to 10 carbon atoms R<sup>7</sup> is hydrogen or an alkyl group having 1 to 10 carbon atoms R<sup>8</sup> is hydrogen, an alkyl group having 1 to 10 carbon atoms, or the below-mentioned formula (12):

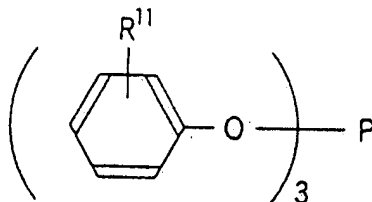
Formula (12)



wherein R<sup>10</sup> in the formula (12) is an alkylene group having 1 to 10 carbon atoms or an alkylidene group having 1 to 10 carbon atoms or an alkylidene group having 1 to 10 carbon atoms R<sup>9</sup> is hydrogen or an alkyl group having 1 to 10 carbon atoms however, at

least one of  $R^7$  and  $R^8$  is a tert-butyl group, or an alkyl group having a cyclohexyl group, moreover, substituents of the same numeral can either be same or different

Formula (16)



wherein  $R^{11}$  is hydrogen or an alkyl group having 1 to 10 carbon atoms.

9. The highly stable resin according to claim 8, wherein the light transmittance of a 3-methoxy butyl acetate solution of a 20% by weight resin solid component placed in a 1 cm square quartz cell at 400 nm is 60% or more.

10. The highly stable resin according to claim 8, wherein the light transmittance of a 3-methoxy butyl acetate solution of a 20% by weight resin solid component placed in a 1 cm square quartz cell at 360 nm is 50% or more.

a<sup>3</sup>

11. (Amended) A highly stable polymer obtainable by reacting a material polymer having a principal chain including at least a component unit having an acidic functional group and a component unit having a hydroxyl group with an isocyanate compound, and further reacting the same with an alcohol until an acid anhydride group is substantially completely vanished.

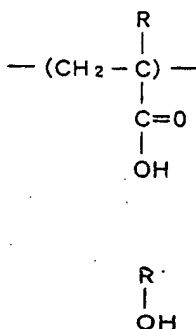
12. The highly stable resin according to claim 11, wherein the material polymer is reacted with the isocyanate compound so as to be bonded with at least a part of the acidic functional group and/or the hydroxyl group via the isocyanate group of the isocyanate compound, and the acid anhydride part produced as a side product of the dehydration

condensation of the acid functional groups by the function of the isocyanate compound is addition-reacted with the alcohol so as to provide the ester bond via the hydroxyl group of the alcohol.

13. The highly stable resin according to claim 11, wherein the principal chain comprises at least a component unit represented by the below-mentioned formula (1) and a component unit represented by the below-mentioned formula (2):

Formula (1)

Formula (



wherein R is hydrogen or an alkyl group having 1 to 5 carbon atoms, and R<sup>1</sup> is an alkylene group having 2 to 4 carbon atoms.

14. The highly stable resin according to claim 11, wherein the isocyanate compound has a reactive group other than the isocyanate group.

15. The highly stable resin according to claim 14, wherein the isocyanate group is a radical polymerizable group containing isocyanate compound.

16. The highly stable resin according to claim 11, wherein the principal chain part of the highly stable resin is formed by polymerization of a compound having a double bond-containing group and an acidic functional group with a compound having a double bond-

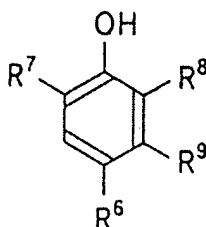
containing group and a hydroxyl group, using a non-nitrile azo-based polymerization initiator or a peroxide-based polymerization initiator.

17. The highly stable resin according to claim 16, wherein the light transmittance of a 3-methoxy butyl acetate solution of a 20% by weight resin solid component placed in a 1 cm square quartz cell at 400 nm is 60% or more.

18. The highly stable resin according to claim 16, wherein the light transmittance of a 3-methoxy butyl acetate solution of a 20% by weight resin solid component placed in a 1 cm square quartz cell at 360 nm is 50% or more.

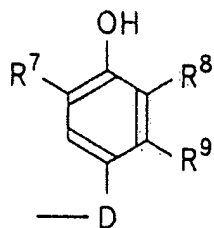
19. (Amended) The highly stable resin according to claim 11, wherein the isocyanate compound is introduced in the principal chain part of the highly stable resin, using a polymerization inhibitor selected from the group consisting of a phenol-based compound represented by the below-mentioned formula (10) and a phosphite-based compound represented by the below-mentioned formula (16):

Formula (10)



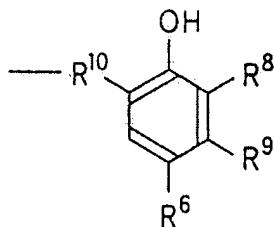
wherein R<sup>6</sup> is hydrogen, an alkyl group having 1 to 5 carbon atoms, or the below-mentioned formula (11):

Formula (11)



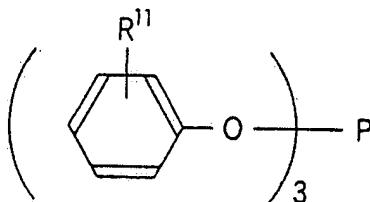
wherein D in the formula (11) is —S—, an alkylene group having 1 to 10 carbon atoms or an alkylidene group having 1 to 10 carbon atoms,  $R^7$  is hydrogen or an alkyl group having 1 to 10 carbon atoms.  $R^8$  is hydrogen, an alkyl group having 1 to 10 carbon atoms, or the below-mentioned formula (12):

Formula (12)



wherein  $R^{10}$  in the formula (12) is an alkylene group having 1 to 10 carbon atoms or an alkylidene group having 1 to 10 carbon atoms or an alkylidene group having 1 to 10 carbon atoms,  $R^9$  is hydrogen or an alkyl group having 1 to 10 carbon atoms however, at least one of  $R^7$  and  $R^8$  is a tert-butyl group, or an alkyl group having a cyclohexyl group, moreover, substituents of the same numeral can either be same or different,

Formula (16)



wherein  $R^{11}$  is hydrogen or an alkyl group having 1 to 20 carbon atoms.

20. The highly stable resin according to claim 19, wherein the light transmittance of a 3-methoxy butyl acetate solution of a 20% by weight resin solid component placed in a 1 cm square quartz cell at 400 nm is 60% or more.

21. The highly stable resin according to claim 19, wherein the light transmittance of a 3-methoxy butyl acetate solution of a 20% by weight resin solid component placed in a 1 cm square quartz cell at 360 nm is 50% or more.

a5 22. (Amended) A production method for a highly stable polymer comprising the steps of reacting a material polymer having a principal chain including at least a component unit having an acidic functional group and a component unit having a hydroxyl group with an isocyanate compound, and further reacting the same with an alcohol until an acid anhydride group is substantially completely vanished.

23. The production method for a highly stable resin according to claim 22, wherein the alcohol is added to the solution of the polymer obtained by reacting the material polymer and the isocyanate compound dissolved or dispersed in a solvent before viscosity rise of the solution or before completion of viscosity rise of the solution.

24. The production method for a highly stable resin according to claim 23, wherein the polymer applied with the alcohol treatment are left or heated for a predetermined time for maturation after the addition of the alcohol.

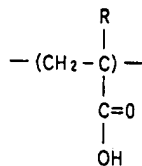
25. The production method for a highly stable resin according to claim 24, wherein the polymer is matured at 30 to 170 °C for a period within 72 hours.

26. The production method for a highly stable resin according to claim 22, wherein the principal chain of the material polymer comprises at least a component unit represented by

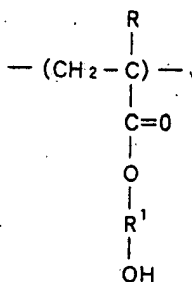


the below-mentioned formula (1) and a component unit represented by the below-mentioned formula (2) :

Formula (1)



Formula (2)



wherein R is hydrogen or an alkyl group having 1 to 5 carbon atoms, and R<sup>1</sup> is an alkylene group having 2 to 4 carbon atoms.

27. The production method for a highly stable resin according to claim 22, wherein the isocyanate compound has a reactive group other than the isocyanate group.

28. The production method for a highly stable resin according to claim 27, wherein the isocyanate group is a radical polymerizable group-containing isocyanate compound.

29. The production method for a highly stable resin according to claim 22, wherein a compound having a double bond-containing group and an acidic functional group is reacted with a compound having a double bond-containing group and a hydroxyl group, using a non-nitrile azo-based polymerization initiator or a peroxide-based polymerization initiator so as to prepare the material polymer, and the material polymer is reacted with the isocyanate compound.

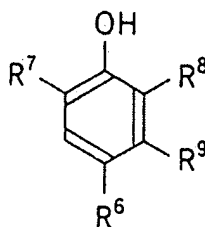
30. The production method for a highly stable resin according to claim 29, wherein a highly stable resin with the light transmittance of a 3-methoxy butyl acetate solution of a 20% by weight resin solid component placed in a 1 cm square quartz cell at 400 nm being 60% or more is obtained.

31. The production method for a highly stable resin according to claim 29, wherein a highly stable resin with the light transmittance of a 3-methoxy butyl acetate solution of a 20% by weight resin solid component placed in a 1 cm square quartz cell at 360 nm being 50% or more is obtained.

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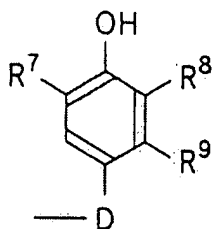
32. (Amended) The production method for a highly stable resin according to claim 22, wherein the isocyanate compound is reacted with the material polymer, using a polymerization inhibitor selected from the group consisting of a phenol-based compound represented by the below-mentioned formula (10) and a phosphite-based compound represented by the below-mentioned formula (16):

Formula (10)



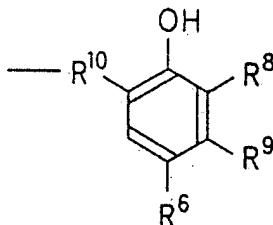
wherein R<sup>6</sup> is hydrogen, an alkyl group having 1 to 5 carbon atoms, or the below-mentioned formula (11):

Formula (11)



wherein D in the formula (11) is -S-, an alkylene group having 1 to 10 carbon atoms or an alkylidene group having 1 to 10 carbon atoms, R<sup>7</sup> is hydrogen or an alkyl group having 1 to 10 carbon atoms, R<sup>8</sup> is hydrogen, an alkyl group having 1 to 10 carbon atoms, or the below:

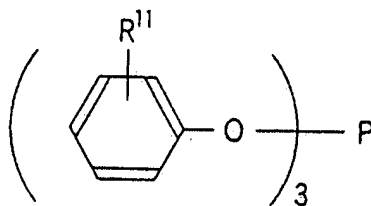
Formula (12)



wherein R<sup>10</sup> in the formula (12) is a alkylene group having 1 to 10 carbon atoms or an alkylidene group having 1 to 10 carbon atoms, R<sup>9</sup> is hydrogen or an alkyl group having 1 to 10 carbon atoms, however, at least one of R<sup>7</sup> and R<sup>8</sup> is a tert-butyl group, or

an alkyl group having a cyclohexyl group. Moreover, substituents of the same numeral can either be same or different,

Formula (16)



wherein R<sup>11</sup> is hydrogen or an alkyl group having 1 to 20 carbon atoms.

33. The production method for a highly stable resin according to claim 32, wherein a highly stable resin with the light transmittance of a 3-methoxy butyl acetate solution of a 20% by weight resin solid component placed in a 1 cm square quartz cell at 400 nm being 60% or more is obtained.

34. The production method for a highly stable resin according to claim 32, wherein a highly stable resin with the light transmittance of a 3-methoxy butyl acetate solution of a 20% by weight resin solid component placed in a 1 cm square quartz cell at 360 nm being 50% or more is obtained.

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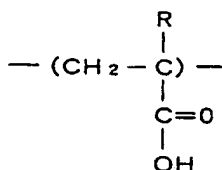
35. (Amended) A hardenable resin composition containing as the essential component a hardenable polymer obtainable by reacting material polymer having a principal chain including at least a component unit having an acidic functional group and a component unit having a hydroxyl group with an isocyanate compound having a hardenable reactive group, and further reacting the same with an alcohol until an acid anhydride group is substantially completely vanished.

36. The hardenable resin composition according to claim 35, wherein the hardenable polymer is obtained by reacting the material polymer with the isocyanate compound and the alcohol, and further being left or heated for a predetermined time for maturation.

37. The hardenable resin composition according to claim 35, containing as the essential component the hardenable polymer dissolved or dispersed in a coating solvent, wherein the hardenable polymer is obtained by reacting the material polymer with the isocyanate compound, and further reacting the same with an alcohol having a boiling point with a 75°C or less difference with respect to the boiling point of the coating solvent to be used and/or an evaporation rate with a 90 ( n-BuOAc=100 ) or less difference with respect to the evaporation rate of the coating solvent.

38. The hardenable resin composition according to claim 35, wherein, the principal chain of the material polymer comprises at least a component unit represented by the below-mentioned formula (1) and a component unit represented by the below mentioned formula (2) :

Formula (1)

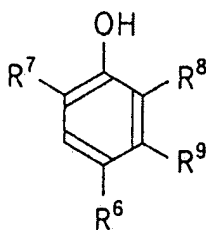


wherein R is hydrogen or an alkyl group having 1 to 5 carbon atoms, and R<sup>1</sup> is an alkylene group having 2 to 4 carbon atoms, and

the isocyanate compound is a radical polymerizable group-containing isocyanate compound.

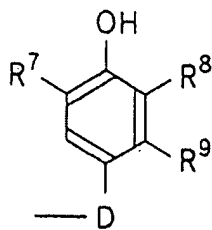
39. (Amended) The hardenable resin composition according to claim 35, wherein the material polymer is formed by polymerization of a compound having a double bond-containing group and an acidic functional group with a compound having a double bond-containing group and a hydroxyl group, using a non-nitrile azo-based polymerization initiator or a peroxide-based polymerization initiator, and the material polymer is reacted with the isocyanate compound, using a polymerization inhibitor selected from the group consisting of a phenol-based compound represented by the below-mentioned formula (10) and a phosphite-based compound represented by the below-mentioned formula (16):

Formula (10)



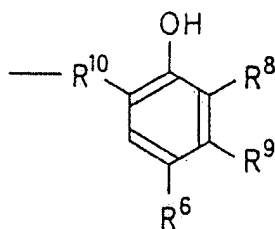
wherein R<sup>6</sup> is hydrogen, an alkyl group having 1 to 5 carbon atoms, or the below-mentioned formula (11):

Formula (11)



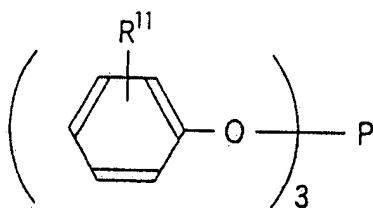
wherein D in the formula (11) is  $-S-$ , an alkylene group having 1 to 10 carbon atoms or an alkylidene group having 1 to 10 carbon atoms,  $R^7$  is hydrogen or an alkyl group having 1 to 10 carbon atoms,  $R^8$  is hydrogen, an alkyl group having 1 to 10 carbon atoms, or the below-mentioned formula (12):

Formula (12)



a<sup>8</sup> wherein  $R^{10}$  in the formula (12) is an alkylene group having 1 to 10 carbon atoms or an alkylidene group having 1 to 10 carbon atoms,  $R^9$  is hydrogen or an alkyl group having 1 to 10 carbon atoms, however, at least one of  $R^7$  and  $R^8$  is a tert-butyl group, or an alkyl group having a cyclohexyl group, moreover, substituents of the same numeral can either be same or different,

Formula (16)



wherein  $R^{11}$  is hydrogen or an alkyl group having 1 to 20 carbon atoms.

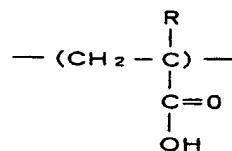
40. The hardenable resin composition according to claim 39, wherein the hardenable resin polymer has a light transmittance of a 3-methoxy butyl acetate solution of a 20% by weight resin solid component placed in a 1 cm square quartz cell at 400 nm being 60% or more.

41. The hardenable resin composition according to claim 39, wherein the hardenable resin polymer has a light transmittance of a 3-methoxy butyl acetate solution of a 20% by weight resin solid component placed in a 1 cm square quartz cell at 360 nm being 50% or more.

42. A production method for a hardenable resin composition comprising the steps of preparing a polymer by reacting a material polymer having a principal chain including at least a component unit having an acidic functional group and a component unit having a hydroxyl group with an isocyanate compound having a hardenable reactive group, preparing a solution by dissolving or dispersing the prepared polymer in a solvent, adding an alcohol to the solution before viscosity rise of the solution or before completion of viscosity rise of the solution for reaction, preparing a hardenable polymer by leaving or heating the polymer applied with the alcohol treatment for a predetermined time for maturation, and mixing the obtained hardenable polymer with other components.

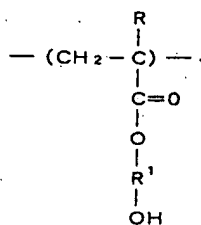
43. The production method for a hardenable resin composition according to claim 42, wherein the principal chain of the material polymer comprises at least a component unit represented by the below-mentioned formula (1) and a component unit represented by the below-mentioned formula (2) :

Formula (1)



Formula (2)





wherein R is hydrogen or an alkyl group having 1 to 5 carbon atoms, and R<sup>1</sup> is an alkylene group having 2 to 4 carbon atoms,

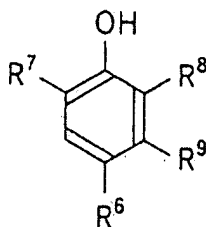
the isocyanate compound is a radical polymerizable group-containing isocyanate compound, and

the polymer is matured at 30 to 170 °C for a period within 72 hours.

44. (Amended) The production method for a hardenable resin composition according to claim 42, wherein the material polymer is prepared by polymerization of a compound having a double bond-containing group and an acidic functional group with a compound having a double bond-containing group and a hydroxyl group, using a non-nitrile azo-based polymerization initiator or a peroxide-based polymerization initiator, and the material polymer is reacted with the isocyanate compound, using a polymerization inhibitor selected from the group consisting of a phenol-based compound represented by the below-mentioned formula (10) and a phosphite-based compound represented by the below-mentioned formula (16):

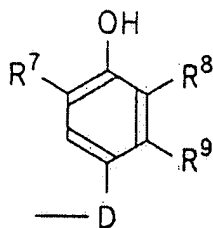
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Formula (10)



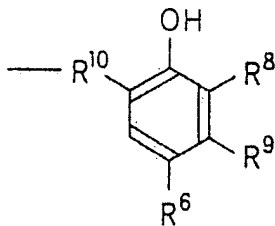
wherein R<sup>6</sup> is hydrogen, an alkyl group having 1 to 5 carbon atoms, or the below-mentioned formula (11):

Formula (11)



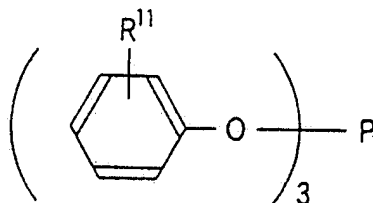
wherein D in the formula (11) is -S-, an alkylene group having 1 to 10 carbon atoms or an alkylidene group having 1 to 10 carbon atoms, R<sup>7</sup> is hydrogen or an alkyl group having 1 to 10 carbon atoms, R<sup>8</sup> is hydrogen, an alkyl group having 1 to 10 carbon atoms, or the below-mentioned formula (12):

Formula (12)



wherein  $R^{10}$  in the formula (12) is an alkylene group having 1 to 10 carbon atoms or an alkylidene group having 1 to 10 carbon atoms,  $R^9$  is hydrogen or an alkyl group having 1 to 10 carbon atoms, however, at least one of  $R^7$  and  $R^8$  is a tert-butyl group, or an alkyl group having a cyclohexyl group, moreover, substituents of the same numeral can either be same or different

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Formula (16)



wherein  $R^{11}$  is hydrogen or an alkyl group having 1 to 20 carbon atoms.

45. The production method for a hardenable resin composition according to claim 44, wherein a polymer having a light transmittance of a 3-methoxy butyl acetate solution of a 20% by weight resin solid component placed in a 1 cm square quartz cell at 400 nm being 60% or more is prepared by reacting the material polymer with an isocyanate compound, and applying the alcohol treatment to the polymer.

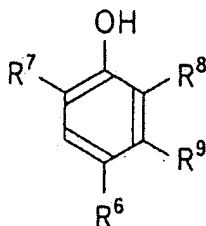
46. The production method for a hardenable resin composition according to claim 44, wherein a polymer having a light transmittance of a 3-methoxy butyl acetate solution of a 20% by weight resin solid component placed in a 1 cm square quartz cell at 360 nm being 50% or more is prepared by reacting the material polymer with an isocyanate compound, and applying the alcohol treatment to the polymer.

47. A production method for a hardenable resin composition containing as the essential component a hardenable polymer dissolved or dispersed in a coating solvent,

comprising the steps of preparing a polymer by reacting a material polymer having a principal chain including at least a component unit having an acidic functional group and a component unit having a hydroxyl group with an isocyanate compound having a hardenable reactive group, preparing a solution by dissolving or dispersing the prepared polymer in a solvent, adding an alcohol having a boiling point with a 75 °C or less difference with respect to the boiling point of the coating solvent to be used and/or an evaporation rate with a 90(n-BuOAc=100) or less difference with respect to the evaporation rate of the coating solvent in the solution before viscosity rise of the solution or before completion of viscosity rise of the solution for reaction so as to prepare a hardenable polymer, and mixing the obtained hardenable polymer with the coating solvent.

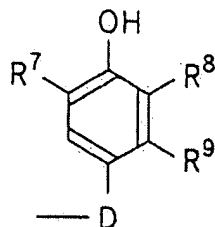
48. (Amended) The production method for a hardenable resin composition according to claim 47, wherein the material polymer is prepared by polymerization of a compound having a double bond-containing group and an acidic functional group with a compound having a double bond-containing group and a hydroxyl group, using a non-nitrile azo-based polymerization initiator or a peroxide-based polymerization initiator, and the material polymer is reacted with the isocyanate compound, using a polymerization inhibitor selected from the group consisting of a phenol-based compound represented by the below-mentioned formula (10) and a phosphite-based compound represented by the below-mentioned formula (16):

Formula (10)



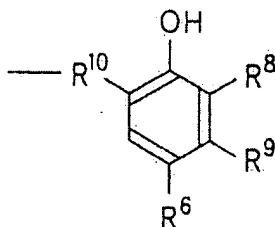
wherein  $R^6$  is hydrogen, an alkyl group having 1 to 5 carbon atoms, or the below-mentioned formula (11):

Formula (11)



wherein D in the formula (11) is  $-S-$ , an alkylene group having 1 to 10 carbon atoms or an alkylidene group having 1 to 10 carbon atoms,  $R^7$  is hydrogen or an alkyl group having 1 to 10 carbon atoms,  $R^8$  is hydrogen, an alkyl group having 1 to 10 carbon atoms, or the below-mentioned formula (12):

Formula (12)



wherein  $R^{10}$  in the formula (12) is an alkylene group having 1 to 10 carbon atoms or an alkylidene group having 1 to 10 carbon atoms,  $R^9$  is hydrogen or an alkyl group having 1 to 10 carbon atoms, however, at least one of  $R^7$  and  $R^8$  is a tert-butyl group, or an alkyl group having a cyclohexyl group, moreover, substituents of the same numeral can either be same or different,

Formula (16)



wherein R<sup>11</sup> is hydrogen or an alkyl group having 1 to 20 carbon atoms.

49. The production method for a hardenable resin composition according to claim 48, wherein a polymer having a light transmittance of a 3-methoxy butyl acetate solution of a 20% by weight resin solid component placed in a 1 cm square quartz cell at 400 nm being 60% or more is prepared by reacting the material polymer with an isocyanate compound, and applying the alcohol treatment to the polymer.

50. The production method for a hardenable resin composition according to claim 48, wherein a polymer having a light transmittance of a 3-methoxy butyl acetate solution of a 20% by weight resin solid component placed in a 1 cm square quartz cell at 360 nm being 50% or more is prepared by reacting the material polymer with an isocyanate compound, and applying the alcohol treatment to the polymer.

51. A color filter comprising a transparent substrate, a coloring layer formed on the transparent substrate, and a protection film for covering the coloring layer, wherein at least one of the coloring layer and the protection layer is formed by hardening a hardenable resin composition containing as the essential component a hardenable polymer obtained by reacting material polymer having a principal chain including at least a component unit having an acidic functional group and a component unit having a hydroxyl group with an isocyanate compound having a hardenable reactive group, and further reacting the same with an alcohol.

52. A color filter comprising a transparent substrate, a coloring layer, and a spacer disposed at a position to be superimposed with a non-display part for maintaining a distance with respect to an electrode substrate to be faced therewith,

wherein the spacer is formed by hardening a hardenable resin composition containing as the essential component a hardenable polymer obtained by reacting material polymer having a principal chain including at least a component unit having an acidic functional group and a component unit having a hydroxyl group with an isocyanate compound having a hardenable reactive group, and further reacting the same with an alcohol.

53. A liquid crystal panel comprising a color filter and an electrode substrate faced with each other, with a liquid crystal compound sealed therebetween,

wherein the color filter comprises a transparent substrate, a coloring layer formed on the transparent substrate, and a protection film for covering the coloring layer, wherein at least one of the coloring layer and the protection layer is formed by hardening a hardenable resin composition containing as the essential component a hardenable polymer obtained by reacting material polymer having a principal chain including at least a component unit having an acidic functional group and a component unit having a hydroxyl group with an isocyanate compound having a hardenable reactive group, and further reacting the same with an alcohol.

54. A liquid crystal panel comprising a color filter and an electrode substrate faced with each other, with a liquid crystal compound sealed therebetween,

wherein the color filter comprises a transparent substrate, a coloring layer, and a spacer disposed at a position to be superimposed with a non-display part for maintaining a distance with respect to an electrode substrate to be faced therewith,